

Date: Thursday, 15/05/2008 8:09:58 AM  
 User: Linda Lacelle

*ASAP Split*  
**Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
 Job Number : 39277  
 Estimate Number : 13310  
 P.O. Number :  
 This Issue : 15/05/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : R & D SM/MED FAB  
 Previous Run : 39251  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A 08-05-13 new issue DD verified by:

Part Number : D37931  
 Drawing Number : PRELIM  
 Project Number : N/A  
 Drawing Revision : PRELIM  
 Material :  
 Due Date : 22/05/2008 Qty: 40 Um: Each

**POSITIVE RECALL** **2**

Additional Product

**PRELIMINARY ISSUE**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet

*MAT NOT PULLED*

Comment: Qty.: 0.5733 sf(s)/Unit Total : 22.9320 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch:

*100997**IB 8-5-22*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3793

Dwg Rev: *PRE*Prog Rev: *PRE**IB 8-5-22*

2-Deburr if necessary

*IB 8-5-22*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*IB 8-5-22*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*8 08/05/22 (+2)*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs *8 326 1 8261**8 08/05/22 (+2)*



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39277

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

SB 08/05/22 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



RET 08.05.23



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/22 (2)

7.0

POWDER COATING

POWDER COATING



M105642



(2X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:20  
320 °F  
11:50

M-L 08/05/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



@.

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08-05-22

9.0

PACKAGING 1

PACKAGING RESOURCE #1



B38540 D350-636-011 x1  
B39189 D350-636-014 x1  
N/A



(2X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

M-L 08/05/22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/23

Comment: FINAL INSPECTION/W/O RELEASE

U 08.05.22

Job Completion



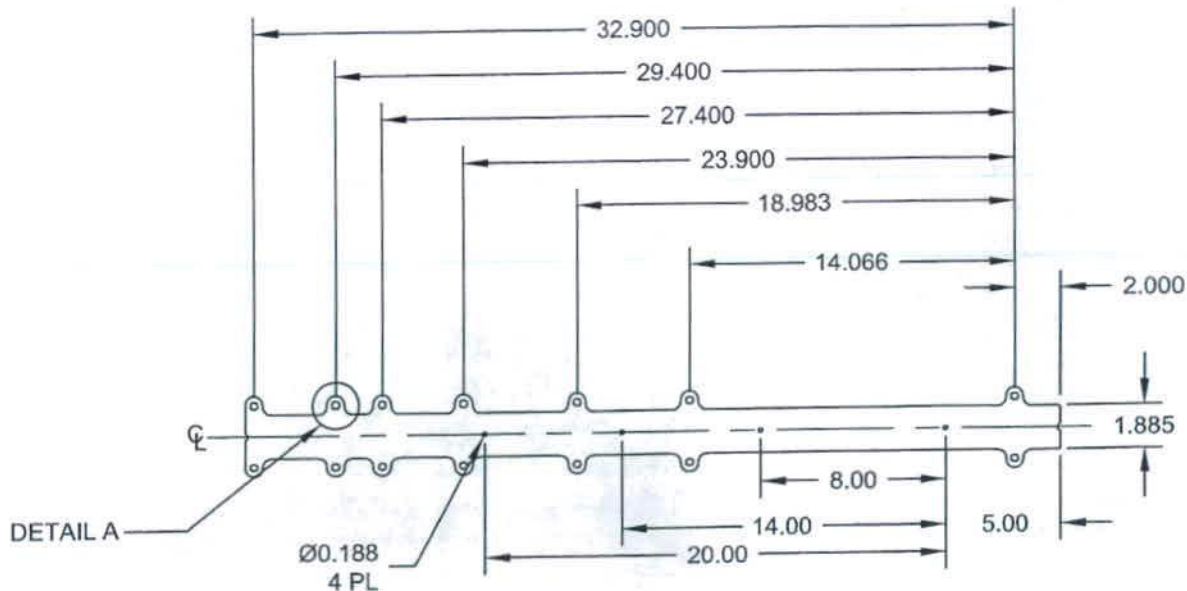
POSITIVE RECALL

EFFECTIVE 08.05.15 AUTH U

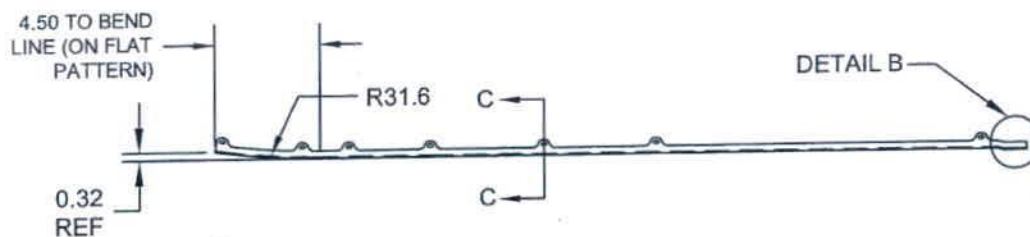
RELEASED U DATE 08.05.22







**D3793-1F FLAT PATTERN**



**D3793-1 BEND DETAIL**

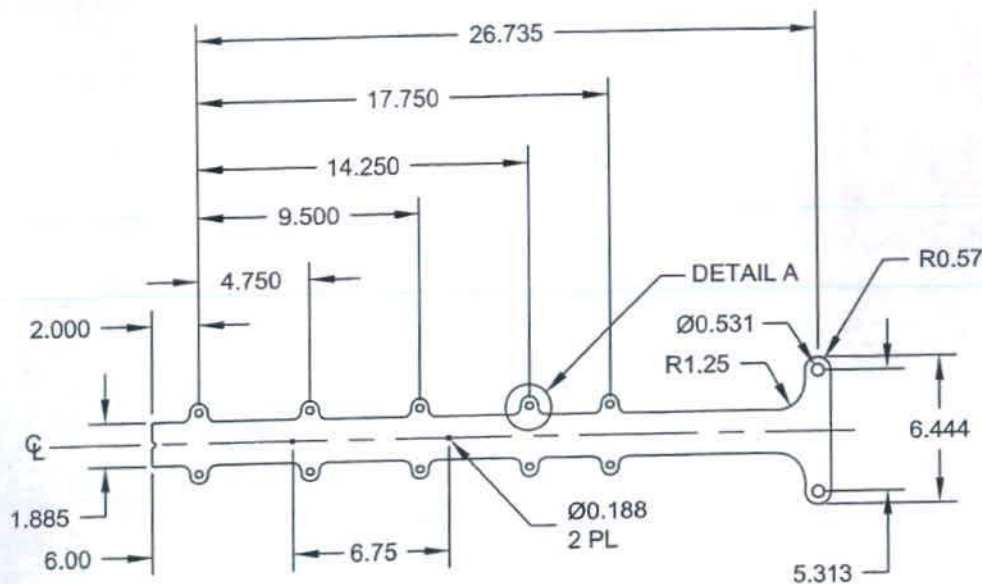
(MAKE FROM D3793-1F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

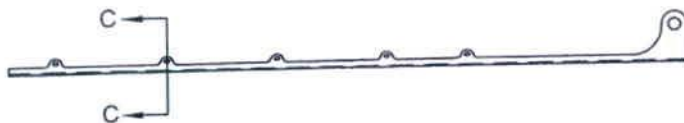
*WLO  
3/22/77*





**D3793-3F FLAT PATTERN**

**PRELIMINARY ISSUE**  
PH 08.05.15



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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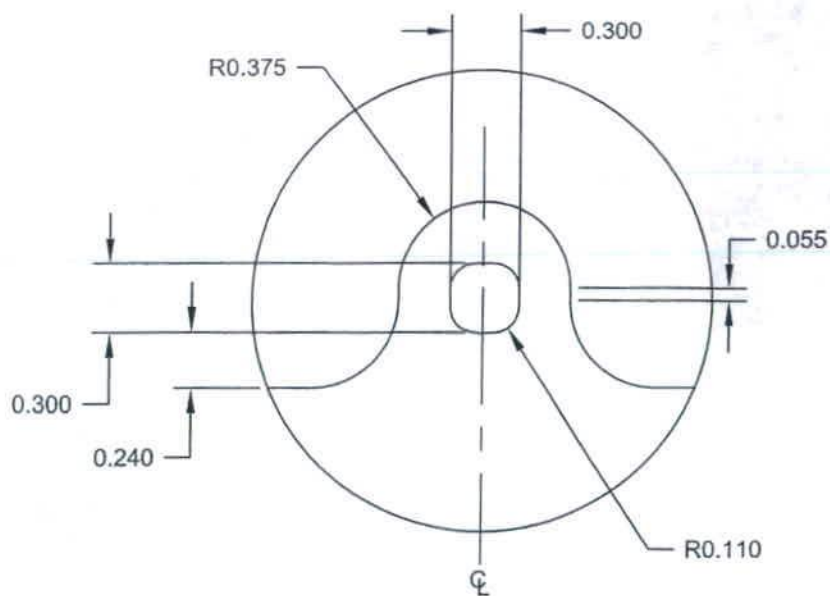
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7

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5

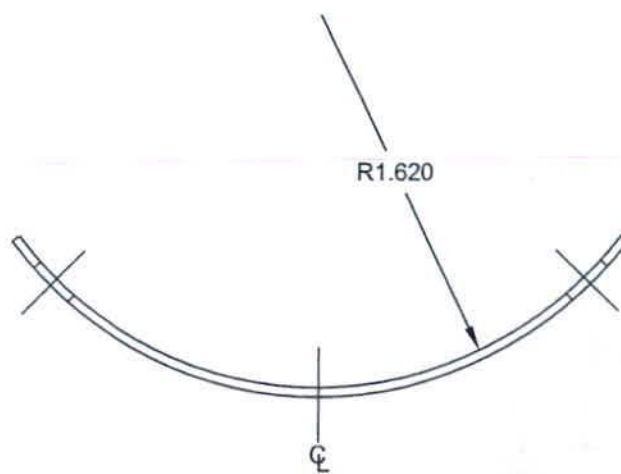
D



C

**DETAIL A**  
SCALE 10X

B



A

**SECTION C-C**  
SCALE 10X

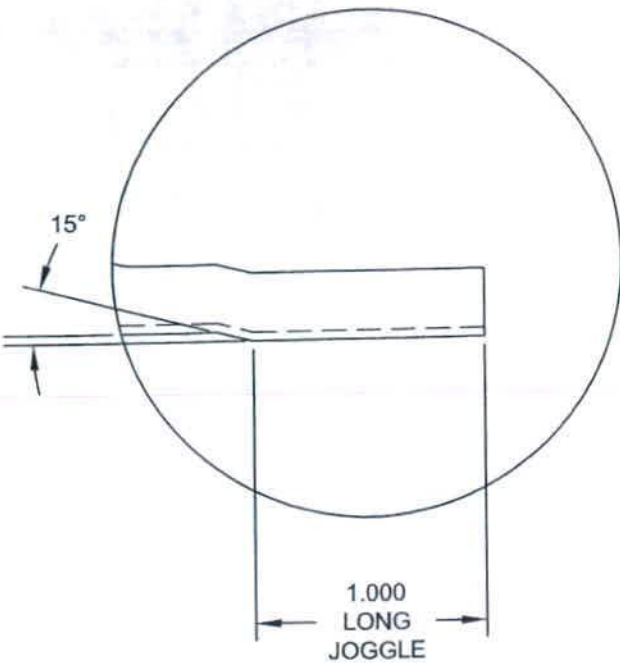
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5





**DETAIL B**  
SCALE 10X

**PRELIMINARY ISSUE**  
PH 08.05.15

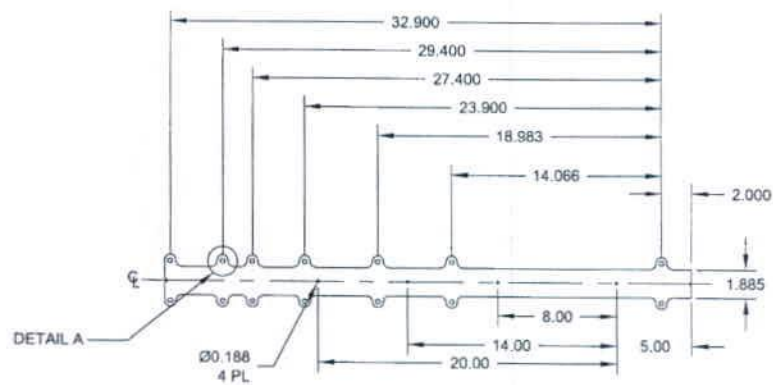
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<del>PH</del>	D3793	SHEET 2 OF 2
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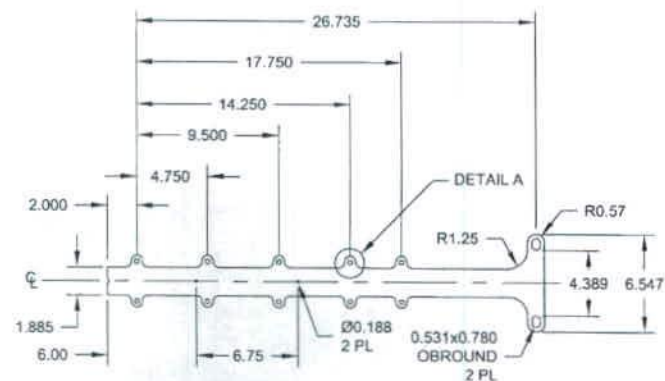




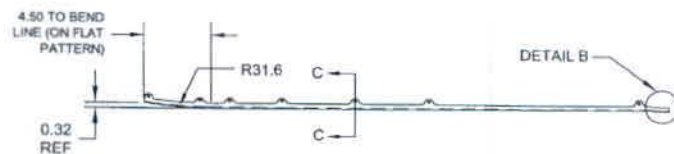
1



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**RELEASED**  
08.05.14

**NOTES:**

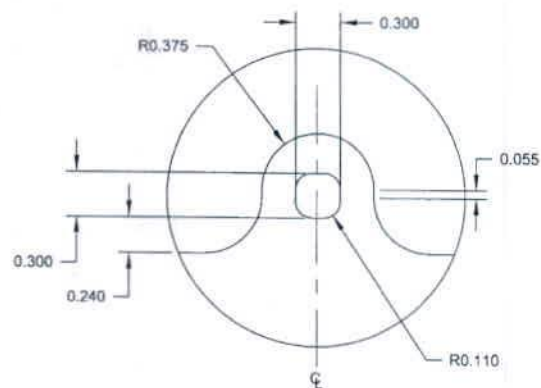
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A		NEW ISSUE		PH	08.05.14
REV.		DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA			
DRAWN	PH				
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3793		SHEET 1 OF 2	
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DE APPR.		WEARSHOE		NTS	
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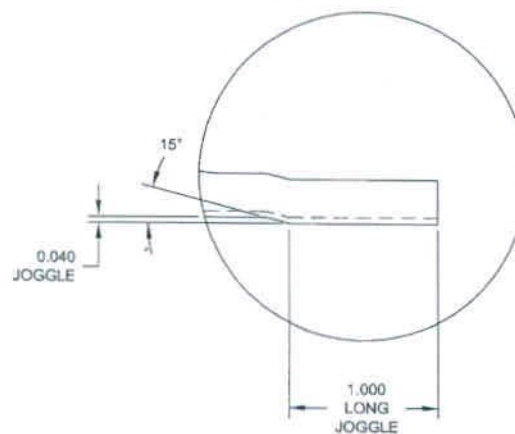




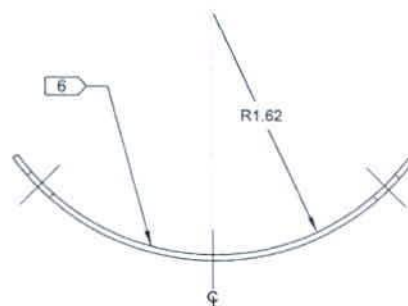
8 7 6 5 4 3 2 1



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

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08-05-14

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8 7 6 5 4 3 2 1

